

Work Order ID 66228

February 8, 2011 8:43:03 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CZ

Date: 11/02/08 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4154

100

0.00

Large Fab

Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

2059 B Hardcoat Welding Rod

BATCH# M117187

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH# M107057

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

CZ 11-4-11 (22)

CZ 11-04-11

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Page 2

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

130

Grey Sandtex(Rel:4 3 5 6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:55

OVEN TEMPERATURE 300°

FINISH TIME: 11:25

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control



Subaru

78

2

BL 16-4-12

2 of 11 1/104/12

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Start Date: 2/08/11 Start Qty: 4.00

Required Date: 2/22/11 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Small Fab

Small Fab

Memo

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154.

160

QC

Quality Control

QC'S- Inspect part completeness to step on W/O

Memo

170

Packaging

Packaging

Identify as per dwg & Stock Location: 1P-9

Memo

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

PER Release Rev.B

W/O: 66228-2

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-04-12	150	coat inside surface of wear plates using Plus 1 Red Guard Black P# 4715	BT	11-04-12	(12)	11.04.12	

Part No: D4154-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4154-041

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Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/13

11-041-13

Picklist Print

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Page 1

Work Order ID: 66228

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly



Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 4.00

Required Qty: 4.00

Comments: JPP Rev:A 10.09.21 new issue DD ver:EC
10.11.04 added DT9684 DD ver:EC

JPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4154-1

Manufactured No

100

Each

6 0000

1

4



Plate



EL 11-4-11

Location

Loc Qty

Loc Code

66173 X 2

WA

6

65079

6

D4155-1

Manufactured No

100

Each

11 0000

1

4



Bar



EL 11-4-11

Location

Loc Qty

Loc Code

ST

2

60976

2

WA

9

62709

1

65080

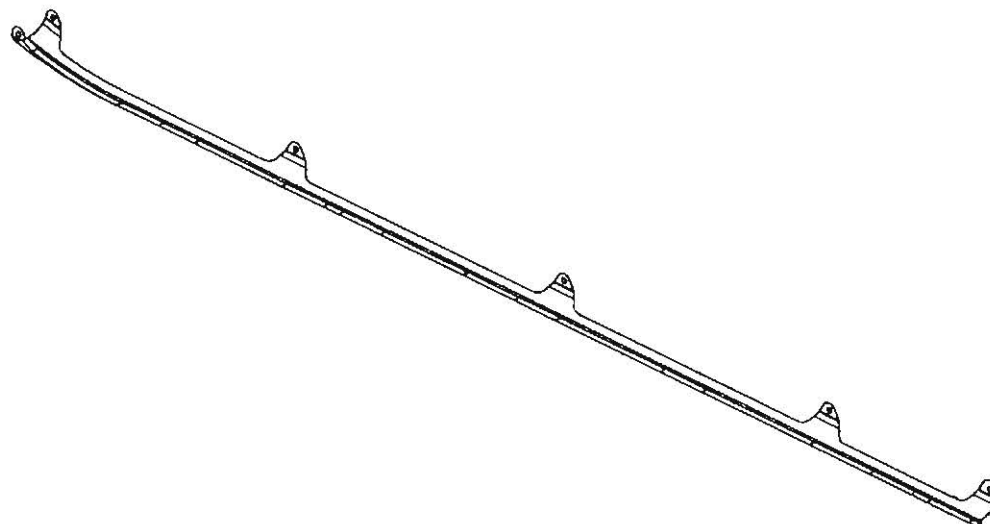
8

66174 X 2

66174 X 2

2

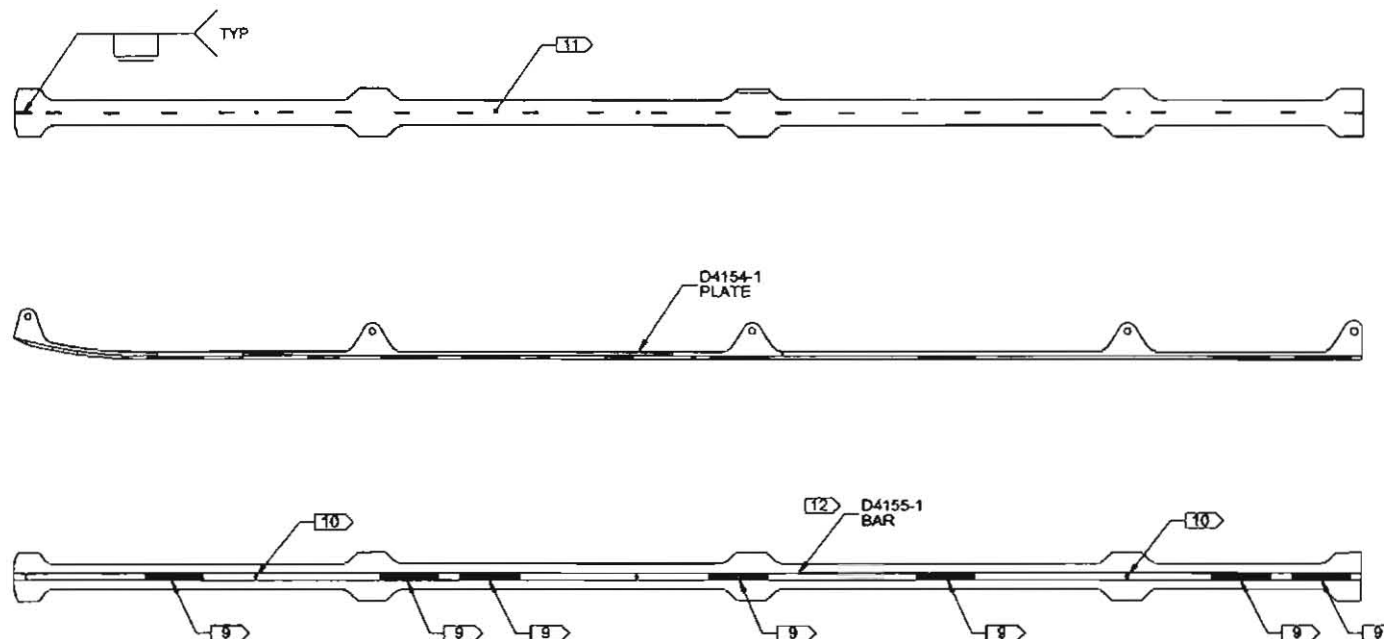
ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2050B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-12
MD

B	ITEM 4 WAS PR1422 (03-1); REMOVED FINISH TO NOTE 2 (AS-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F		MB	11.04.05
A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SE	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	SE	REV. B		
CHECKED	MD	DRAWING NO.	SHEET 1 OF 3	
MFG. APPR.	MD	D4154	SCALE	
APPROVED	MD	TITLE	NTS	
DE APPR.	MD	WEARPLATE ASSEMBLY		
DATE	11.04.05		<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.</small>	



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2050B HARD COAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL $\phi 0.168$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D4154	SHEET 2 OF 3
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	WEARPLATE ASSEMBLY	NTS
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